

Work Order ID 55625

Page 1

January 25, 2010 1:28:37 PM

Item ID:	D3589-5		Accept		Setup	Start		
Revision ID:						Stop		
Item Name:	LATCH GUIDE		10					
Start Date:	1/25/10	Start Qty:	6.00					
Required Date:	2/01/10	Req'd Qty:	6.00					
Reference:								
Approvals:	Process Plan:	PL	Date: 10-1-25	Tooling:	Date:	Run	Start	
	QC:		Date:	SPC (Y/N):	Date:	Stop		

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3589	Rev B								
100		0.00							
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	1-TURN AS PER FOLIO FA755 & DWG D3589 FOLIO REV: B DWG REV: B								
	2-DEBURR AS REQUIRED								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

SA 10/02/2011

10 6

10 6

SA 10/02/2011

10 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55625

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January 25, 2010 1:28:37 PM

Item ID: D3589-5

Accept



Setup Start



Revision ID:

Item Name: LATCH GUIDE

Stop



Start Date: 1/25/10 Start Qty: 6.00



Cust Item ID:

Required Date: 2/01/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC8- Inspect parts- second check

0.00

M.A 10/02/01

10 0

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: 72

0.00

Packaging

Memo

0.00

Packaging

140



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

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NOTE: Date & initial all entries

Picklist Print

Page 1

January 25, 2010 1:28:41 PM

Work Order ID: 55625



Parent Item: D3589-5



Parent Item Name: LATCH GUIDE

Start Date: 1/25/10

Required Date: 2/01/10

Comments: IPP Rev:A 08-05-29 new issue DD verified by:EC IPP Rev:B 09-02-20 rev.b asper dwg DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch Purchased	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.500W.049			No			100	f	86.5100	1.6421			

304 RD Tube .500 x .049W



Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT	86.5099895
111814	86.5099895

26 ft \times 10/02/01

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	<i>33625</i>
Description: Latch Guide	Part Number:	D3589-5
Inspection Dwg: D3589 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>S.A</u>	Audited by:	<u>S.A</u>	Prototype Approval:	N/A
Date:	10/02/01	Date:	10/02/01	Date:	N/A

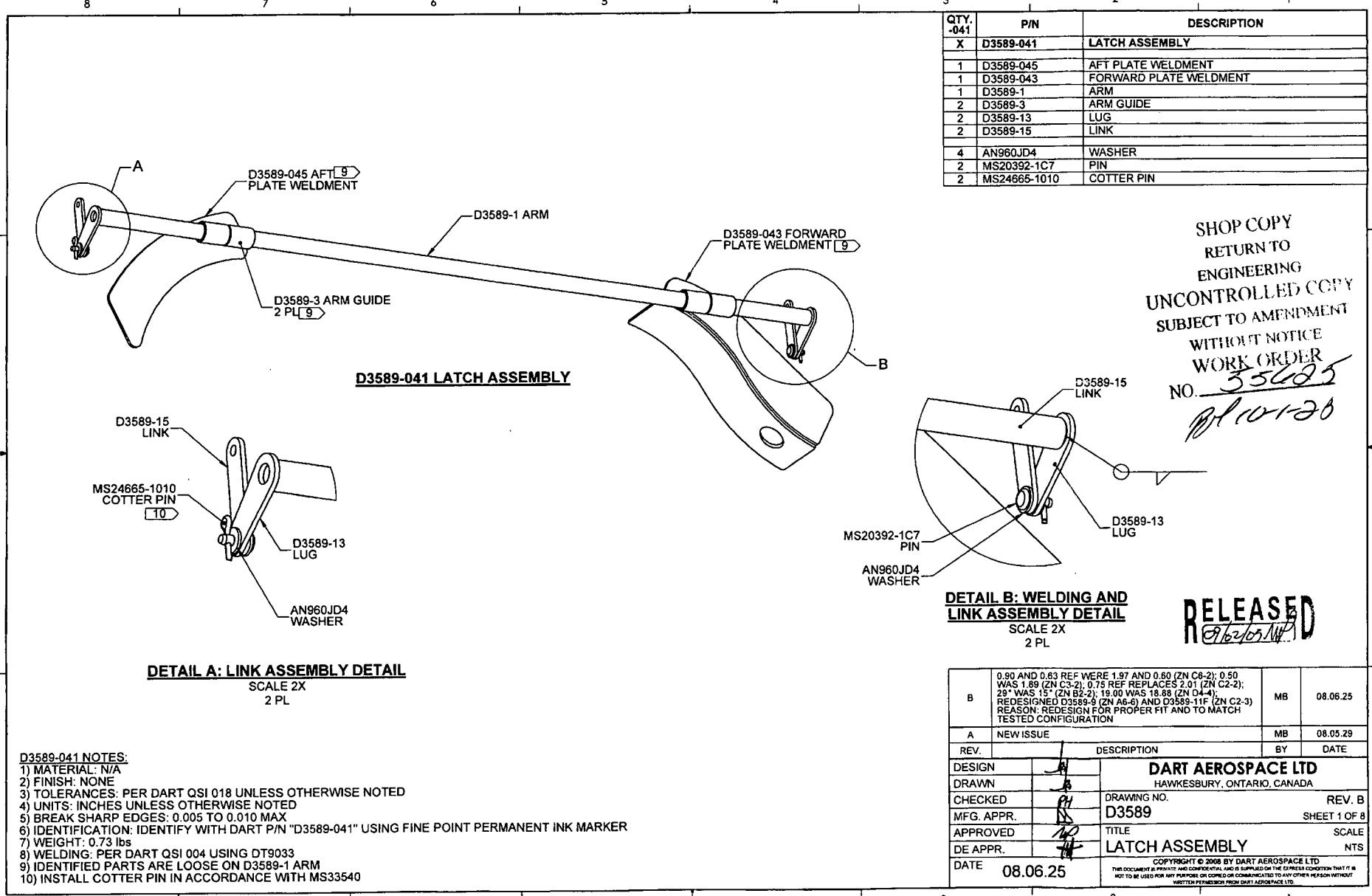
Rev	Date	Change	Revised by	Approved
A	09.05.07	New Issue	KJ/EC	

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NOTE: Date & initial all entries

8

7

6

5

4

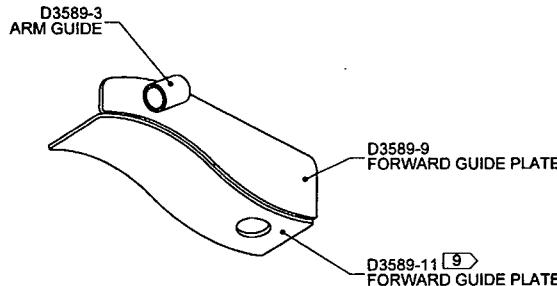
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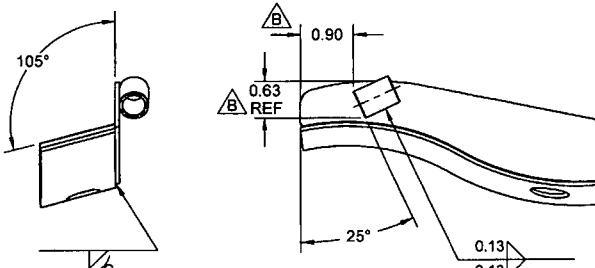
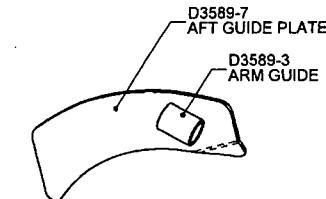
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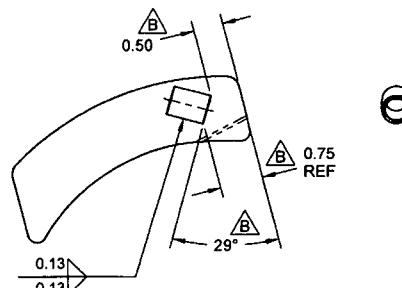
D



QTY -043	QTY -045	P/N	DESCRIPTION
X		D3589-043	FORWARD PLATE WELDMENT
X		D3589-045	AFT PLATE WELDMENT
1	1	D3589-3	ARM GUIDE
	1	D3589-7	AFT GUIDE PLATE
1		D3589-9	FORWARD GUIDE PLATE
1		D3589-11	FORWARD GUIDE PLATE



D3589-043 FORWARD PLATE WELDMENT



D3589-045 AFT PLATE WELDMENT

D3589-043/045 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
 - D3589-043 = 0.22 lbs
 - D3589-045 = 0.10 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) FORM D3589-11 TO FIT D3589-9 MATING EDGE

DESIGN	<i>1</i>	DART AEROSPACE LTD	
DRAWN	<i>1</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>1</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>1</i>	D3589	SHEET 2 OF 8
APPROVED	<i>1</i>	TITLE	
DE APPR.	<i>1</i>	SCALE	
DATE	08.06.25	NTS	

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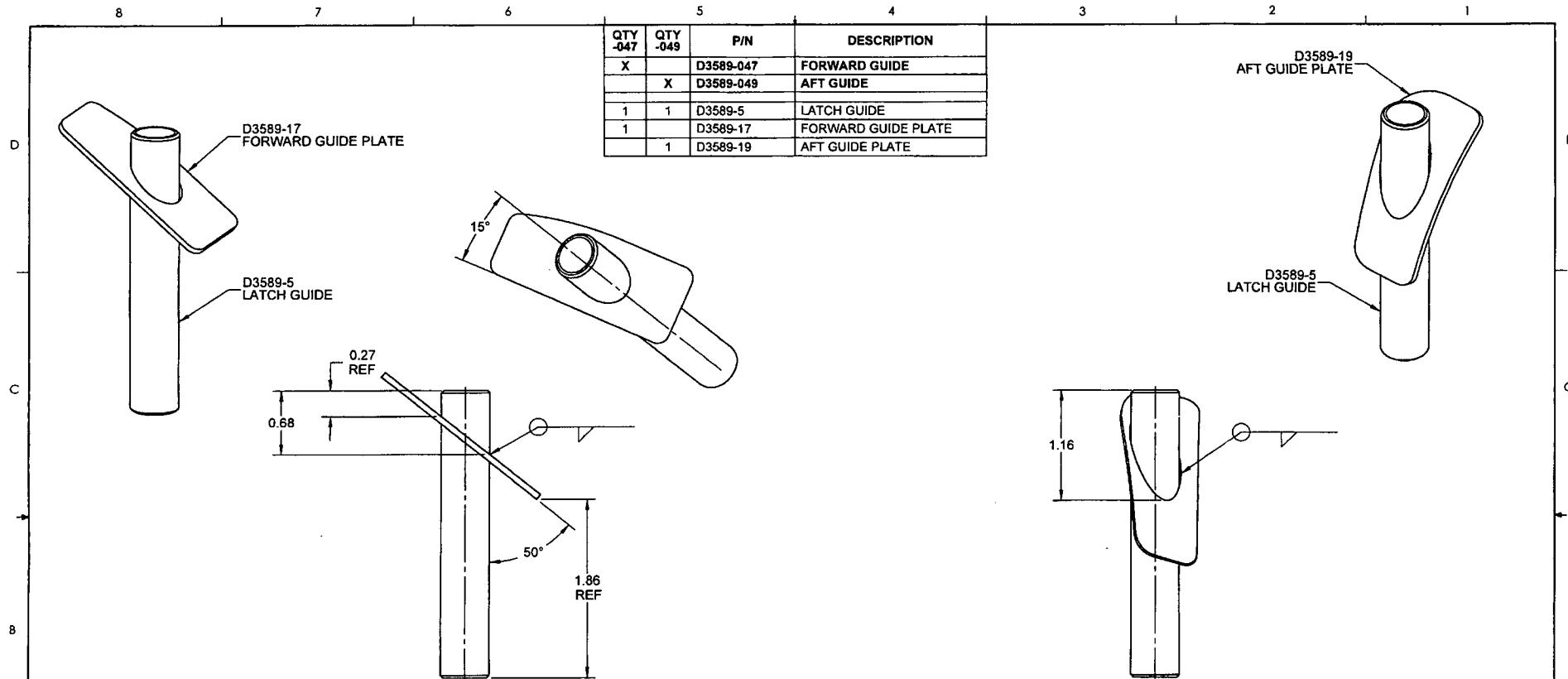
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3589-047 FORWARD GUIDE

D3589-049 AFT GUIDE

D3589-047/-049 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.07 lbs EACH
- 8) WELDING: PER DART QSI 004

DESIGN	<i>1</i>	DART AEROSPACE LTD
DRAWN	<i>5</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>04</i>	DRAWING NO.
MFG. APPR.	<i>XX</i>	REV. B
APPROVED	<i>1</i>	D3589
DE APPR.	<i>1</i>	SHEET 3 OF 8
DATE 08.06.25		NTS

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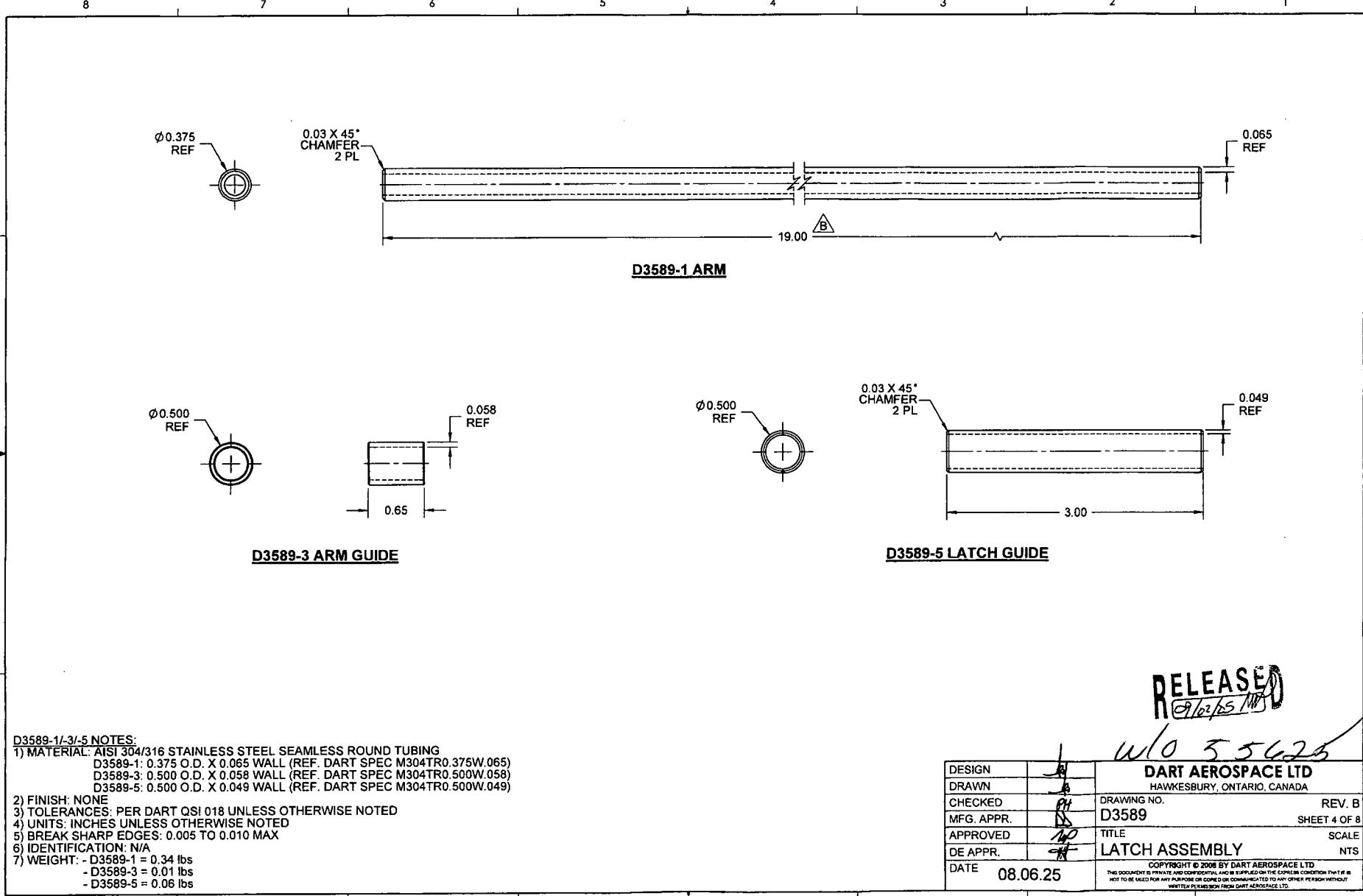
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

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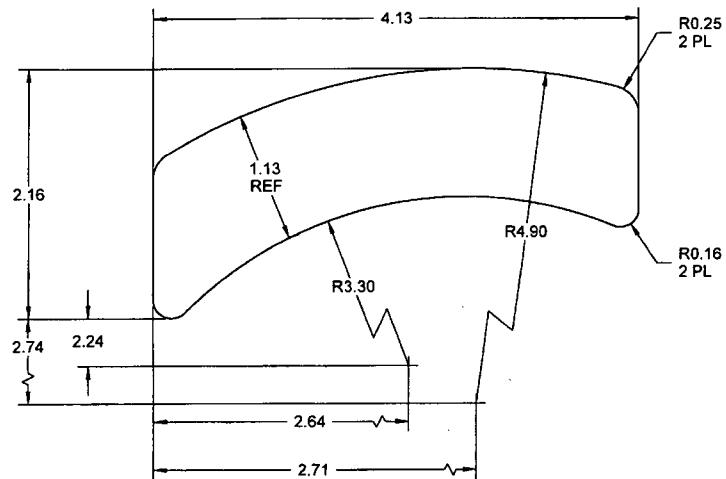
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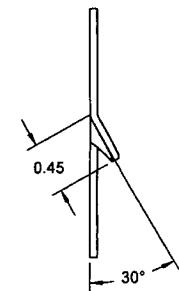
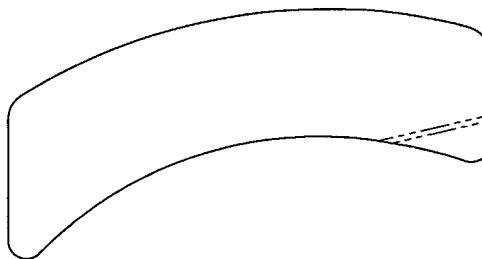
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B

B



D3589-7F AFT GUIDE PLATE
FLAT PATTERN



D3589-7 AFT GUIDE PLATE
MAKE FROM D3589-7F

A

A

D3589-7-7F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (.063 THICK). (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs

DESIGN	<i>1</i>	DART AEROSPACE LTD
DRAWN	<i>1</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>1</i>	DRAWING NO.
MFG. APPR.	<i>1</i>	REV. B
APPROVED	<i>1</i>	D3589
DE APPR.	<i>1</i>	SHEET 5 OF 8
DATE	08.06.25	TITLE
		SCALE
		NTS
		LATCH ASSEMBLY

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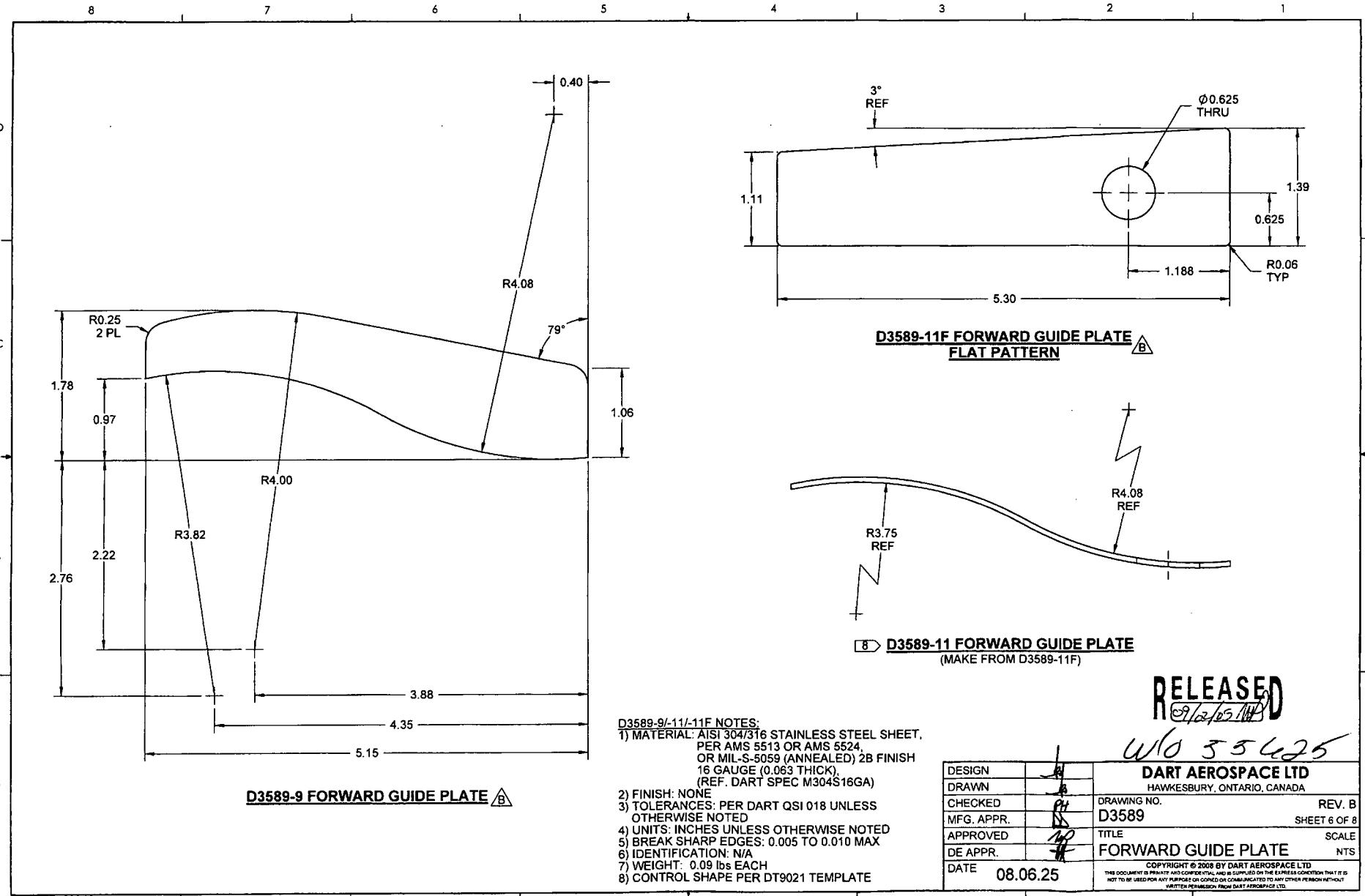
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W/O:		WORK ORDER CHANGES					
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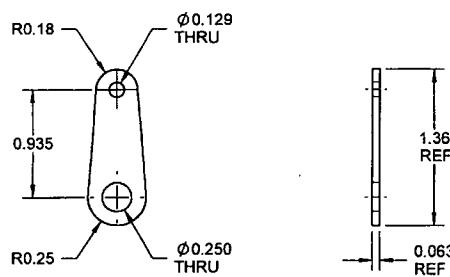
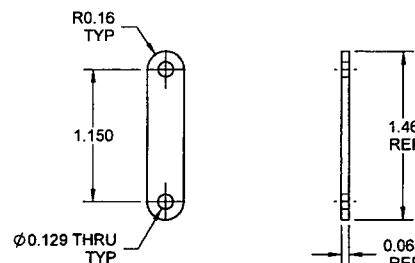
D

C

C

B

B

D3589-13 LUGD3589-15 LINK

A

A

D3589-13-15 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs EACH

8 7 6 5 4 3 2 1

DESIGN	<i>W</i>	DART AEROSPACE LTD	
DRAWN	<i>B</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PT</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>PT</i>	D3589	SHEET 7 OF 8
APPROVED	<i>W</i>	TITLE	SCALE
DE APPR.	<i>W</i>	LATCH ASSEMBLY	NTS
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09/02/05 10:01
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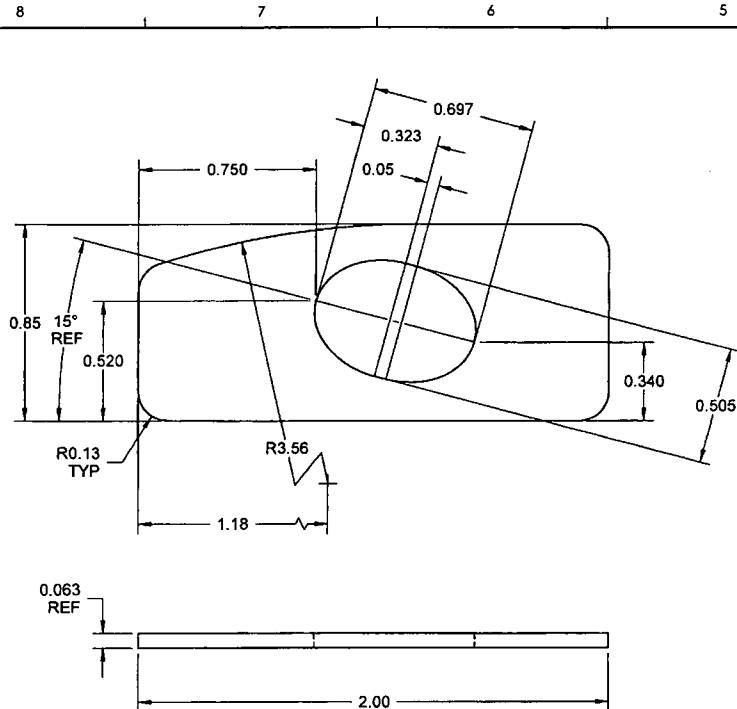
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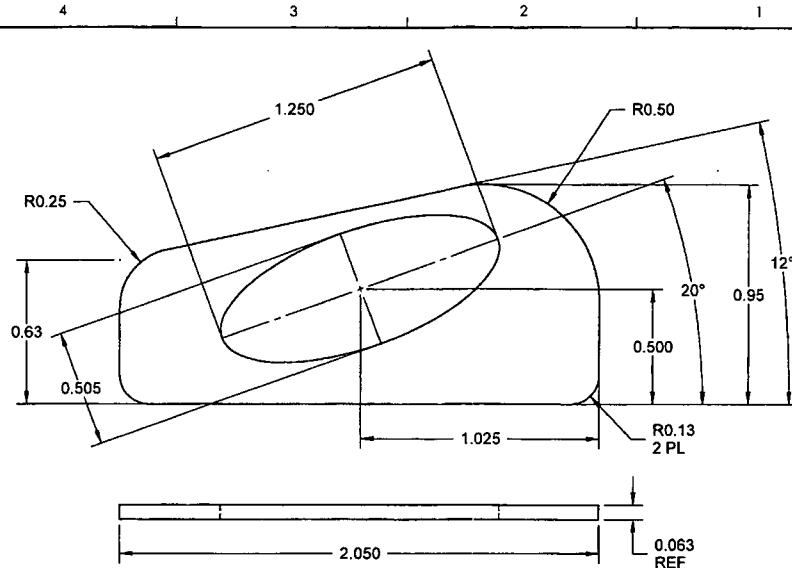
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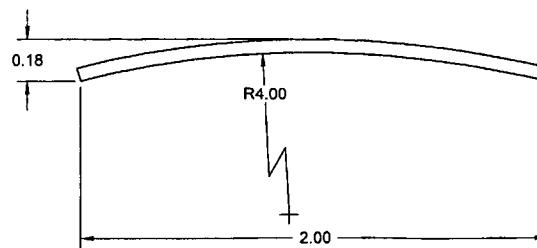
NOTE: Date & initial all entries



D3589-17 FORWARD GUIDE PLATE



D3589-19F AFT GUIDE PLATE FLAT PATTERN



**D3589-19 AFT GUIDE PLATE
(MAKE FROM D3589-19F)**

RELEASED
09/03/2018

44055425
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	<i>AB</i>	DRAWING NO.	REV. B
DRAWN	<i>AB</i>	D3589	SHEET 8 OF 8
CHECKED	<i>AB</i>		
MFG. APPR.	<i>AB</i>		
APPROVED	<i>AB</i>	TITLE	SCALE
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